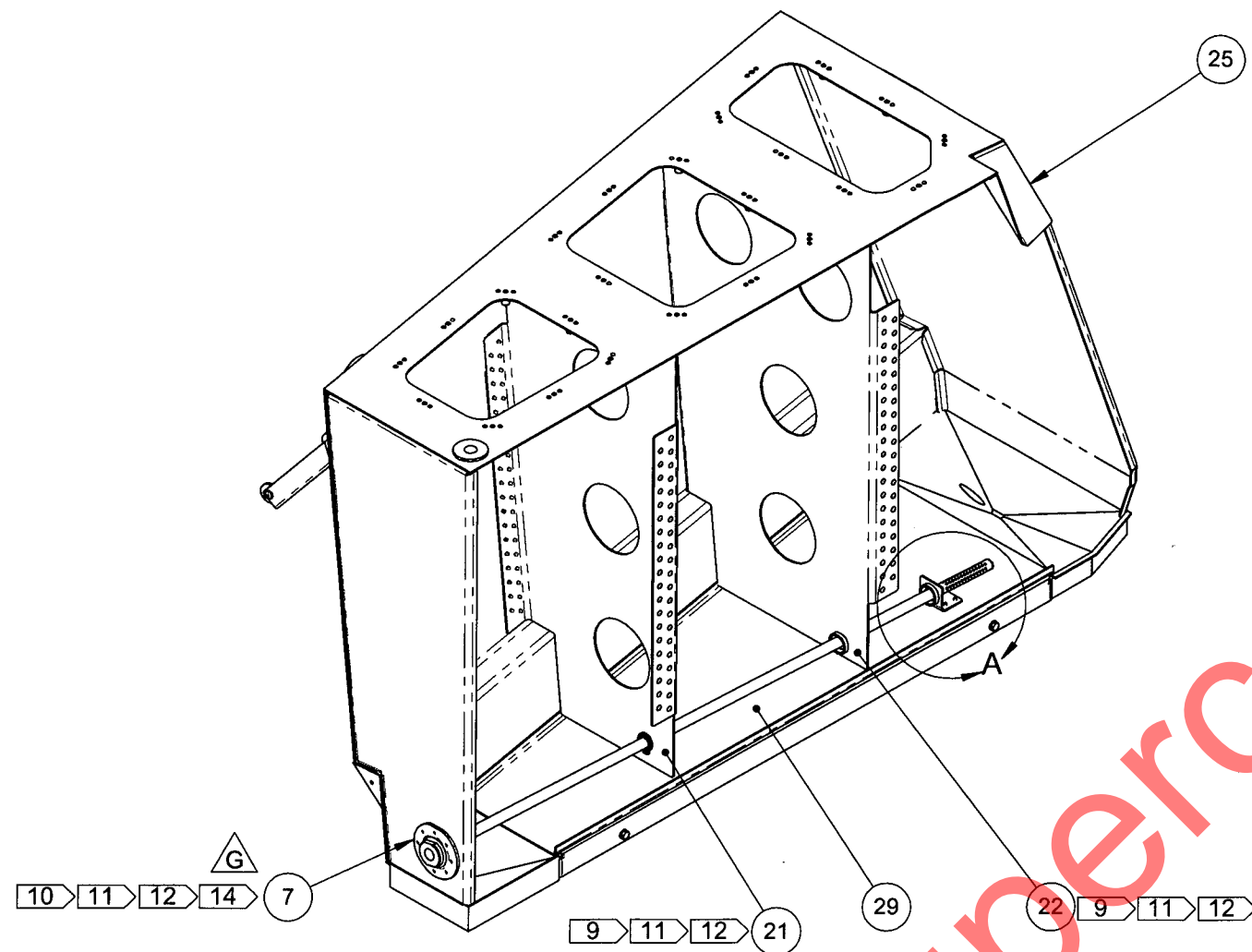


**D4464-041 FUEL TANK ASSEMBLY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1  
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
  - 7) WEIGHT: 39.09 lbs
  - 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 6.3. VERIFY NO LEAKS
  - 9) MASK PRIOR TO FINISH
  - 10) INSTALL AFTER FINISH
  - 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
  - 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
  - 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

**RELEASED**  
**UNDER REVIEW** 2015 JAN 15  
 15.01.30 CC

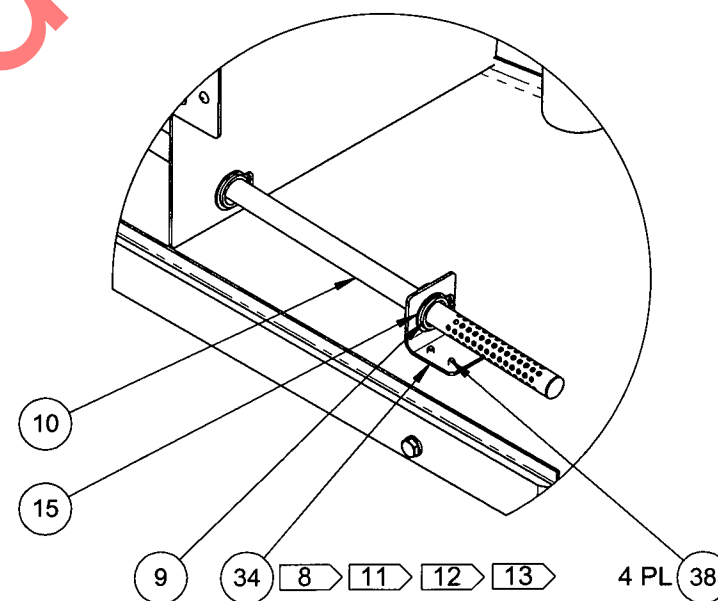
APPROVED	DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	DB	DRAWING NO. <b>D4464</b>	REV. G
	MFG. APPR.	JLM	SHEET 2 OF 4	
	APPROVED	MP	TITLE <b>TANK ASSEMBLY</b>	SCALE NTS
	DE APPR.	DS	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
	DATE	14.12.05		



**D4464-041 FUEL TANK ASSEMBLY**  
D4463-9 TANK BACK REMOVED  
TO SHOW INTERIOR DETAIL

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL  $\phi 0.128$  HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES  $\phi 0.225 \times 100^\circ$  FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS



**DETAIL A**  
ROTATED FOR CLARITY  
SCALE 2X

**UNDER REVIEW**

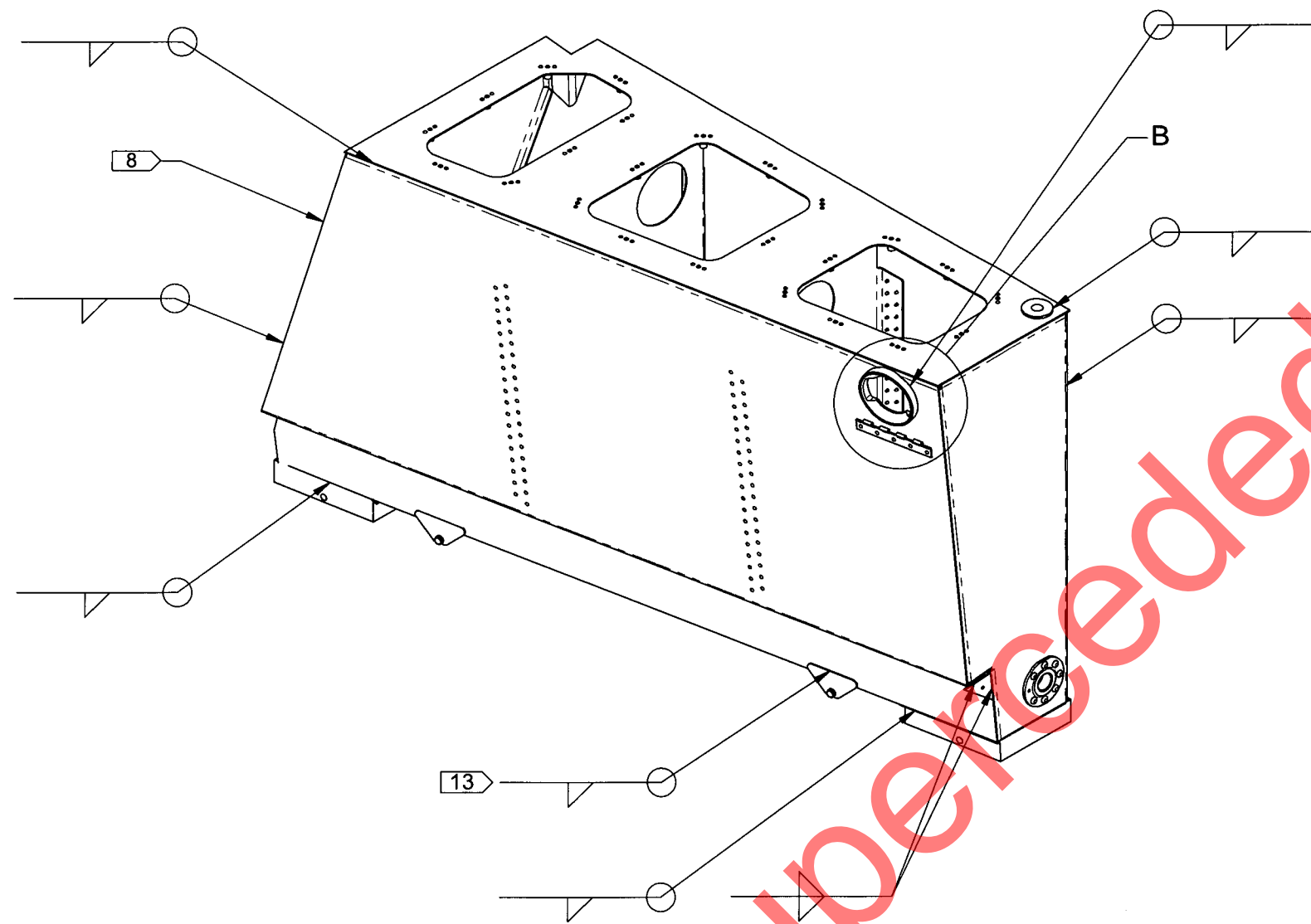
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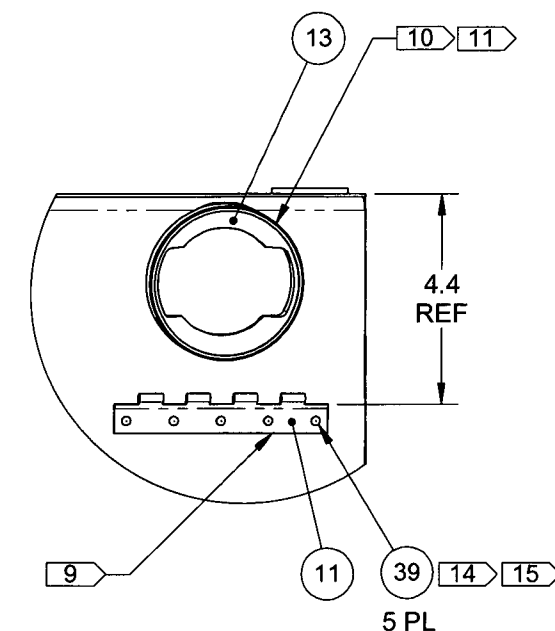
2015 JAN 15

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DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JLM		SHEET 3 OF 4
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DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
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**D4464-041 FUEL TANK ASSEMBLY**  
WELDING AND RIVETING DETAIL



**DETAIL B**  
ROTATED FOR CLARITY  
SCALE 2X

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
- 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B  
AND WET INSTALL MS20470AD4-4 RIVETS
- 15) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

**UNDER REVIEW**

15.01.30 CC

**RELEASED**

2015 JAN 15 *ap*

APPROVED

DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
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